

SHIP 3/1/08

# Work Order ID 51572

August 26, 2009 3:04:04 PM



Item ID: D3869-1

Revision ID: A

Item Name: Top Antenna Ground Plane

Start Date: 8/26/09 Start Qty: 4.00

Required Date: 8/28/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3869

Dwg Rev: 2

Prog Rev: 2

2- Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

Cust Item ID:

Customer:

4

IB 9-8-28

MAY NOT PULL IN

4

IB 9-8-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51572

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Item ID: D3869-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Top Antenna Ground Plane

Start Date: 8/26/09 Start Qty: 4.00



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 502/0568

QC

✓

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

08-08-31

QC

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09/08/31

4

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51572

August 26, 2009 3:04:04 PM



Page 3

Item ID: D3869-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Top Antenna Ground Plane

Start Date: 8/26/09 Start Qty: 4.00



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

09/08/31 (4)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/31 JJ

mk  
09-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

August 26, 2009 3:04:03 PM

Work Order ID: 51572

Parent Item: D3869-1RevA

Parent Item Name: Top Antenna Ground Plane

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.020	6061 T6	Purchased	No			100	sf	44.0000	8.9200			



Alum. sheet .020



AB 9-8-08

6061 T6. 020

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

44

103504

44

112442

112442

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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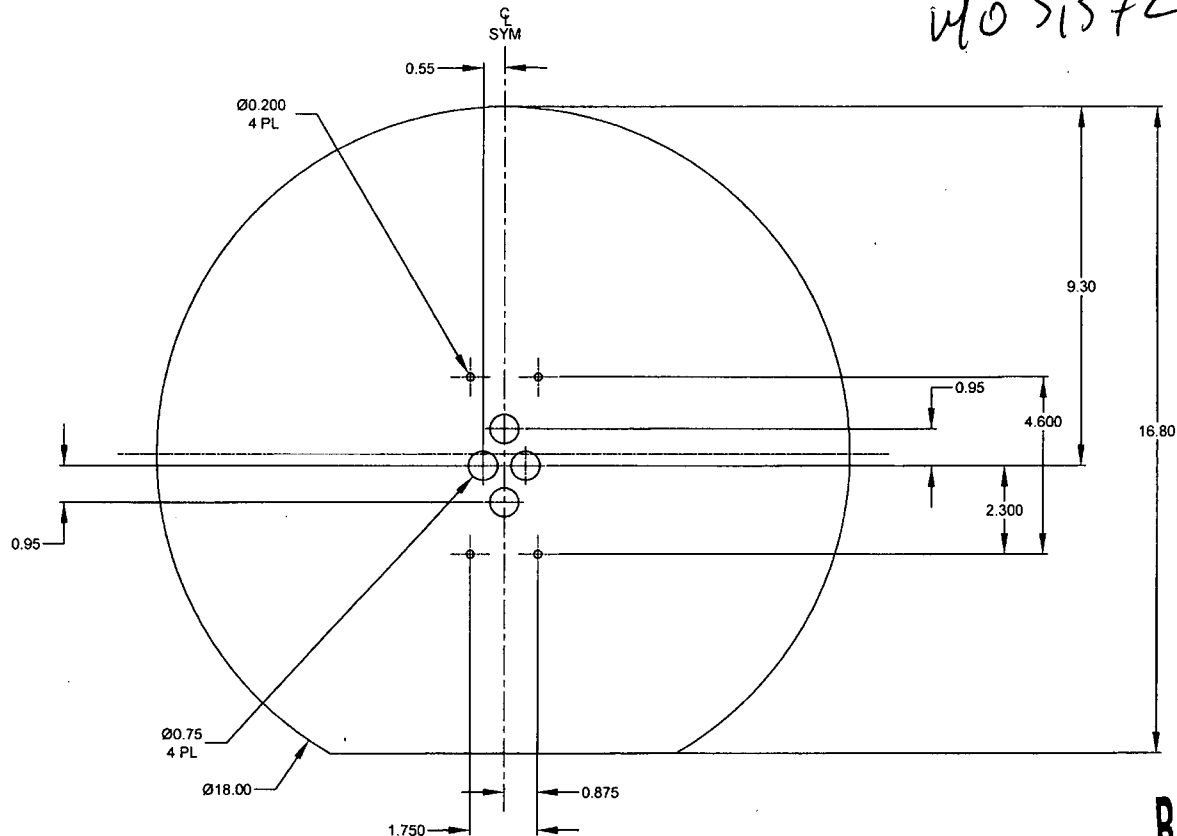
**NOTE:** Date & initial all entries





8 7 6 5 4 3 2 1

WLO 51572



RELEASED  
09/05/05 MRP

### D3869-1 TOP ANTENNA GROUND PLANE

#### NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.020 THICK PER AMS-QQ-A-250/4 (REF DART SPEC M2024T3S.020)  
OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.020 THICK PER AMS-QQ-A-250/11 (REF DART SPEC M6061T6S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3869-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.5 lbs

A	NEW ISSUE			KB	09.01.21
REV.	DESCRIPTION			BY	DATE
DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	KB				
CHECKED	<del>KB</del>	DRAWING NO.	REV. A		
MFG. APPR.	DD	D3869	SHEET 1 OF 1		
APPROVED	<del>KB</del>	TITLE	SCALE		
DE APPR.	<del>KB</del>	TOP ANTENNA GROUND PLANE	NTS		
DATE	09.01.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD			
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8 7 6 5 4 3 2 1